

Work Order ID 69165

Tuesday, May 03, 2011 1:40:02 PM



Page 1

Item ID:	D3914-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib					
Start Date:	5/3/2011	Start Qty:	6.00			
Required Date:	5/17/2011	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:		Date:	11-05-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								

100		0.00							
Large Fab									
Large Fab	Memo	0.00							
	1- Cut tube as per dwg D3914								
	2- debur and remove identification markings								

110	QC6- Inspect dimensions to drawing	0.00							
QC									
Quality Control	Memo	0.00							

120	Identify as per dwg & Stock Location:	0.00							
Packaging									
Packaging	Memo	0.00							

SAD 11-05-13

Cpl 11-05-13

Cpl 11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69165

Tuesday, May 03, 2011 1:40:02 PM



Page 2

Item ID: D3914-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 5/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 J

H1105-16

(6)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 1:40:07 PM

Work Order ID: 69165



Parent Item: D3914-1



Parent Item Name: Rib

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.750W.049

Purchased

No

100

f

95.0561

8

50.52632



SAD 11-05-13

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

26.3249

117029

26.3249

MAT034

68.7312

117337

68.7312

min 890

—————> 50.5264

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

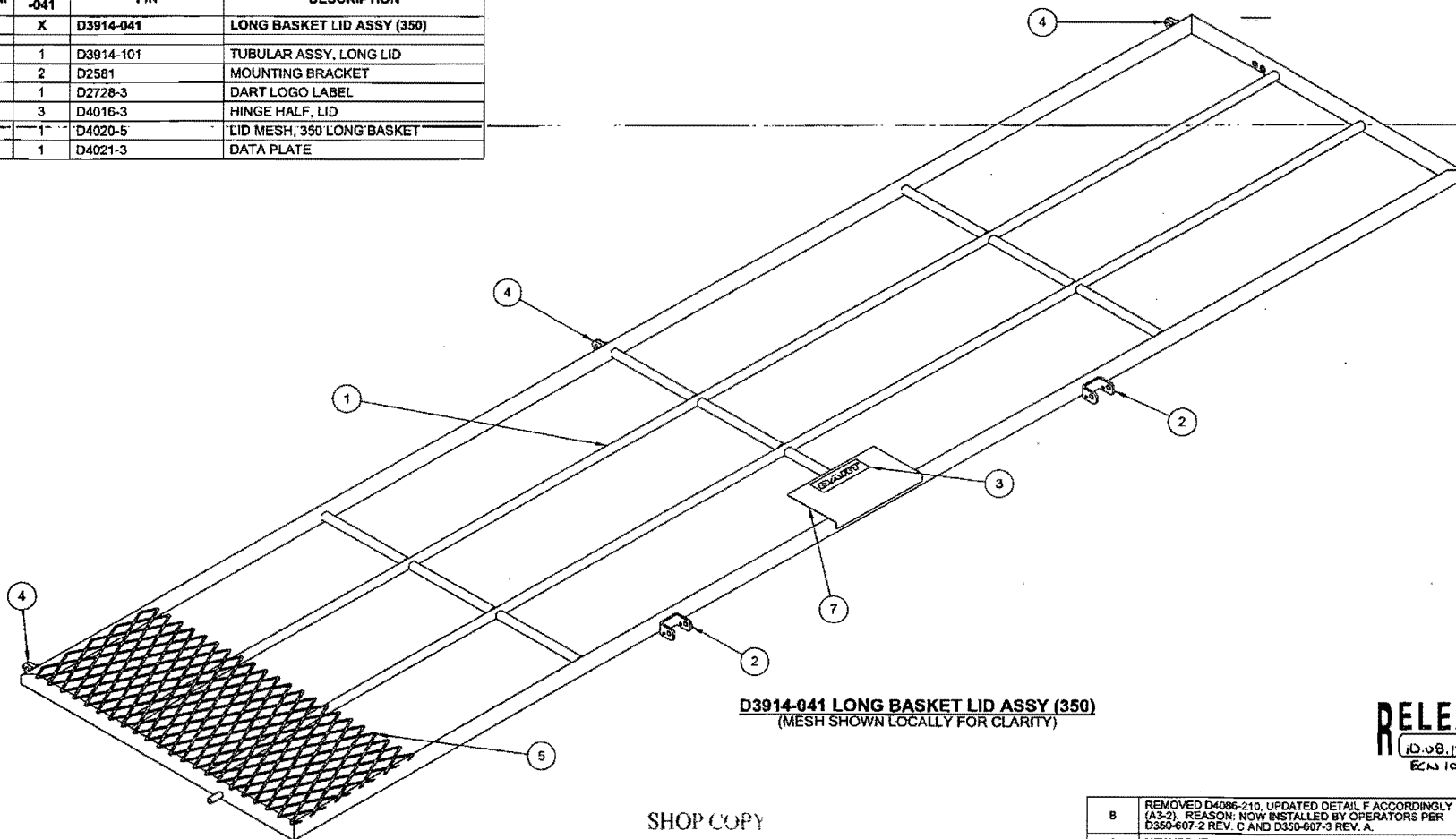
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17 CP
ECN 10-596

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 09145

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	WJ		
APPROVED	WJ		
DE APPR.			
DATE	10.08.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3914	REV. B
TITLE LONG BASKET LID ASSY (350)	SCALE NTS
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11-05-3

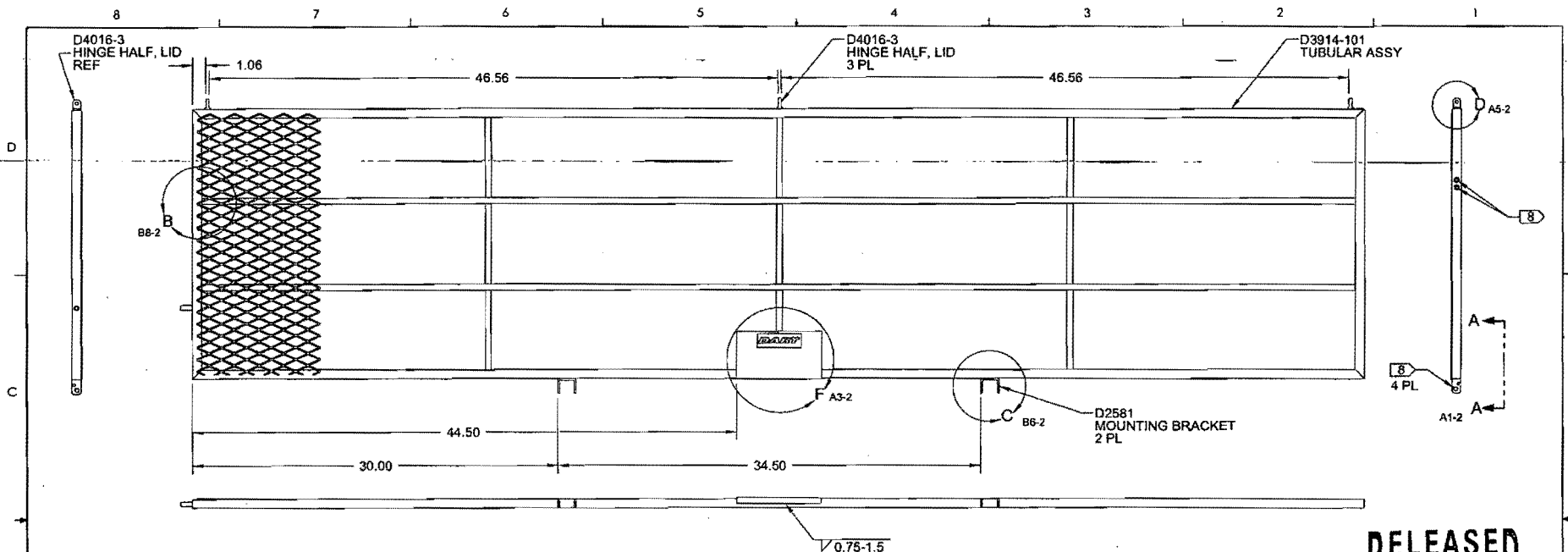
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

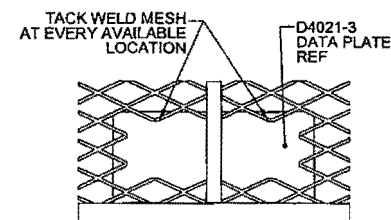
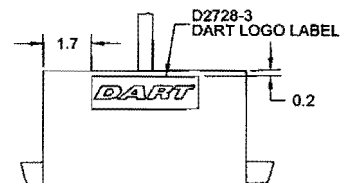
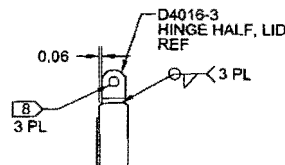
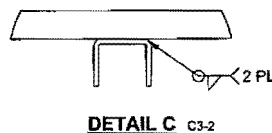
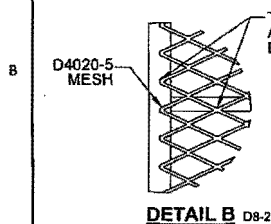
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 UP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

u/o 69165

DESIGN	AIS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC		SHEET 2 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET LID ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.08.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED FOR UNAUTHORIZED USE OR FOR OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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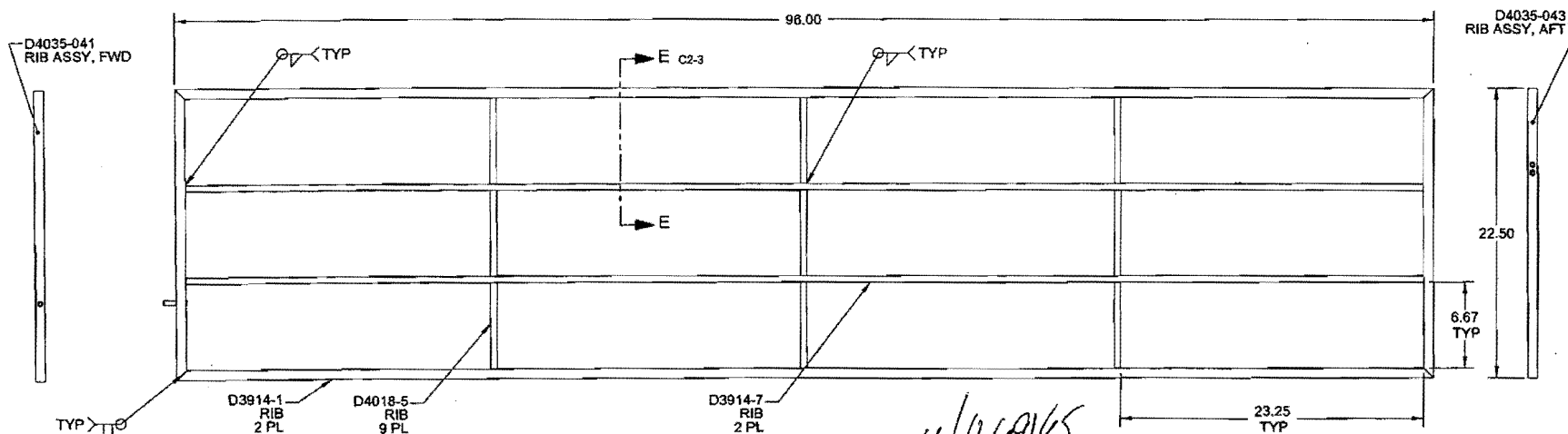
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10 FEB 12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
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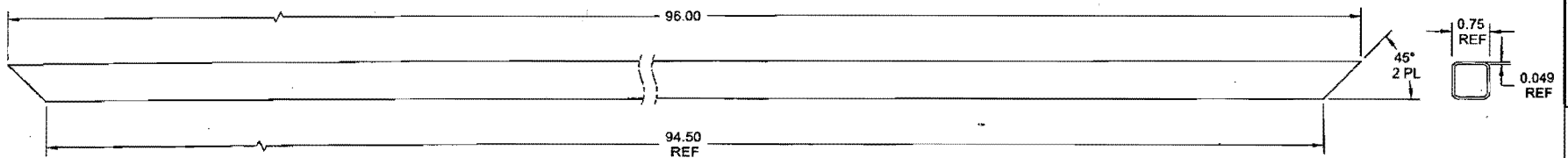
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

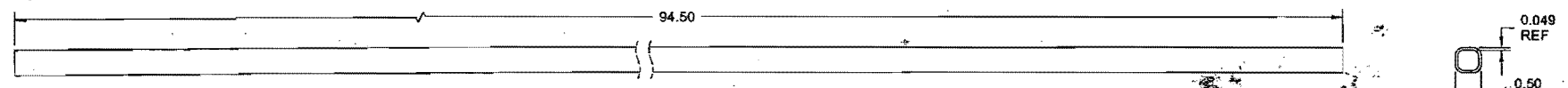
D



D3914-1 RIB

C

C



D3914-7 RIB

B

B

u/o 69165

RELEASED
10.08.12.09

NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

A

A

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	JP	D3914	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	LONG BASKET LID ASSY (350)	NTS
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8 7 6 5 4 3 2 1

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